Work Order ID 94214

November-30-12 10:13:34 AM

94214

Item ID: D3121-143 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 11/30/12 **Start Qty:** 4.00 *4*

Required Date: 12/14/12 **Req'd Qty:** 4.00 *4*

Reference: **Cust Item ID:** **Customer:**

Approvals: **Process Plan:** MLJ **Date:** 12-12-04 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3121	**Revision Nbr** Rev E								
100		0.00							
100	BAND SAW								
Bandsaw	**Memo**	0.00	ok 12/12/18			8	0		
Jeaspa Bandsaw	Cut blanks: (1.250" x 2.000") 4.425" long								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	**Memo**	0.00	ok 12/12/24			8	0		
HAAS CNC vertical machine #1	1-Machine D3121-113 as per Folio FA330 and Dwg D3121 Identify as D3121-113 2-Deburr 3-Scribe batch number								
120	QC2- Inspect parts off machine FAI/FAIB	0.00	ok 12/12/24						
120						8	0		
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 94214

94214

November-30-12 10:13:34 AM

Item ID: D3121-143 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 11/30/12 **Start Qty:** 4.00 *4*

Required Date: 12/14/12 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	12/12/28			8	0		DAS 08 9-89
130									
QC	**Memo**	0.00							
Quality Control									
140		0.00				8X			13/01/14
140	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	Assemble D3121-143 as per Dwg D3121.								
150	QC5- Inspect part completeness to step on W/O	0.00				8			DAS 15 9-89
150									
QC	**Memo**	0.00							13-1-15
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Work Order ID 94214

94214

November-30-12 10:13:34 AM

Item ID: D3121-143 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 11/30/12 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 12/14/12 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: SD235A	0.00				8x			8D
160									3-01-15
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00					13/1/17		DJ
170									
QC	**Memo**	0.00							
Quality Control									

11/30/15

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

November-30-12 10:13:34 AM

Work Order ID: 94214

Parent Item: D3121-143 **Start Date:** 11/30/12 **Required Date:** 12/14/12

Parent Item Name: Bracket Assembly **Start Qty:** 4.00 **Required Qty:** 4.00

Comments: IPP Rev:Pick:A04.02.18New issueKJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-21 Bolt		Manufactured	No			140	Each	33.0000	2	8			
				Location		**Loc Qty**		**Loc Code**					
				ST235		33							
					66969	1							
					79732	4							
					85660	1							
					89495	1							
					89961	26							
D3121-241 Bearing Assembly		Manufactured	No			140	Each	13.0000	2	8			
				Location		**Loc Qty**		**Loc Code**					
				FG		4							
					89826	4							
				ST235A		9							
					93573	9							
M174B1.250X02.000 17-4 SS Bar 1.250 x 2.00		Purchased	No			100	f	36.6683	0.368	**1.5494736**			
				Location		**Loc Qty**		**Loc Code**					
				MAT031		6.23							
					122244	6.23							
				MAT050		30.4383							
					114899	2							
					115806	0.805							
					117483	3.3							
					123294	24.3333				3.09			

13/01/14

B92366 (16x)

13/01/14

B91954 (16x)

OK 12/12/18

NO PWRL

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DART AEROSPACE LTD	Work Order:	94214
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080	✓		Vern	ML-06
0.300	+/-0.010	.300	✓		"	
R0.375	+/-0.010	R.375	✓		"	
1.54	+/-0.030	1.540	✓		"	
0.350	+/-0.010	.350	✓		"	
R0.25	+/-0.030	R.250	✓		R-6	
Ø0.392	+0.002/-0.000	Ø.3933	✓		Micr	ML-07
Ø0.201	+0.005/-0.000	Ø.201	✓		Vern	ML-06
2.540	+/-0.010	2.541	✓		"	
1.590	+/-0.010	1.591	✓		"	
0.160	+/-0.010	.161	✓		"	
0.400	+/-0.010	.408	✓		"	
1.220	+/-0.010	1.228	✓		"	
1.600	+/-0.010	1.603	✓		"	
3.80	+/-0.030	3.800	✓		"	
1.800	+/-0.010	1.803	✓		"	
R0.50	+/-0.030	R.500	✓		R-6	
0.130	+/-0.010	.131	✓		Vern	ML-06
3.41	+/-0.030	3.410	✓		"	
3.65	+/-0.030	3.630			Test-indicator	
2.24	+/-0.030	2.210	✓		Vern	ML-06
45°	+/-0.1°	45°	✓		C-Square	ML-CBD
R0.25	+/-0.030	R.250	✓		R-6	
3.97	+/-0.030	3.970	✓		Vern	ML-06
R0.38	+/-0.030	R.380	✓		R-6	
Ø0.392	+0.002/-0.000	Ø.3933	✓		Micr	ML-07
Ø0.201	+0.005/-0.000	Ø.201	✓		Vern	ML-06
0.268	+/-0.010	.268	✓		"	
R0.260	+/-0.010	R.260	✓		R-6	
0.080	+/-0.010	.080	✓		Vern	ML-06
0.300	+/-0.010	.300	✓		"	
0.381	+/-0.010	.381	✓		"	
0.201	+/-0.010	.201	✓		"	
0.580	+/-0.010	.585	✓		"	

DART AEROSPACE LTD	Work Order:	94214
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: E		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.397	—		V.ern	ML-06
100°	+/-0.1°	100	—			
0.032	+0.000/-0.010	.030	—		D-6	ML-05

Measured by:		Audited by:	DAS 08 9-89	Prototype Approval:	N/A
Date:	12/12/24	Date:	12/12/28	Date:	N/A

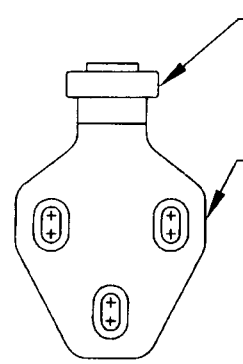
Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-143	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	

DART

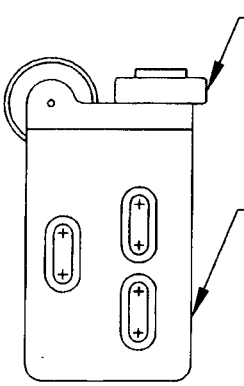
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3121 — REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY — SCALE 1:2

A	02.04.15	NEW ISSUE
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146
C	04.02.17	ADD CLEARANCE; USE -241 BEARING
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)

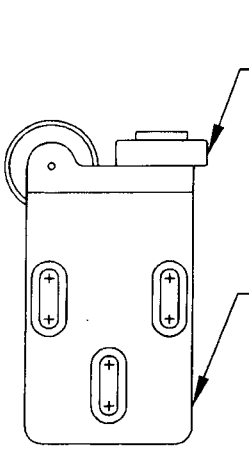
RELEASED
07.11.07



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)

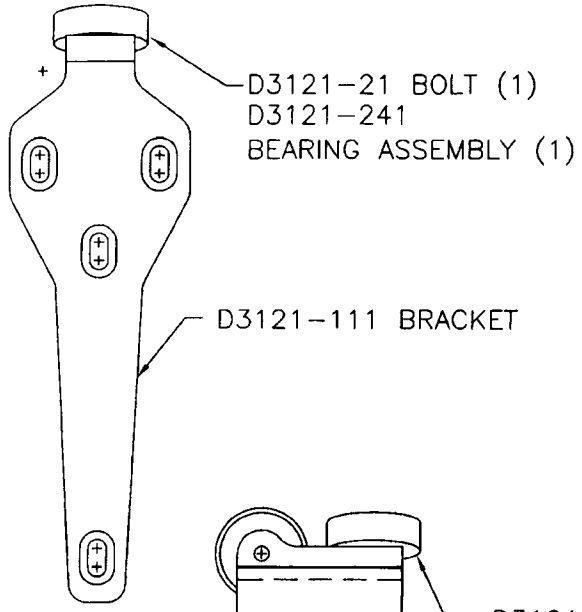


D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



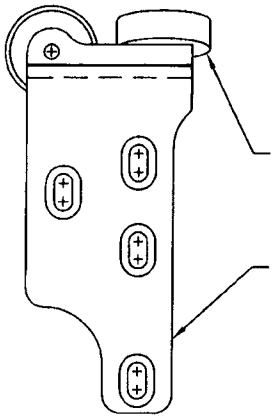
D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

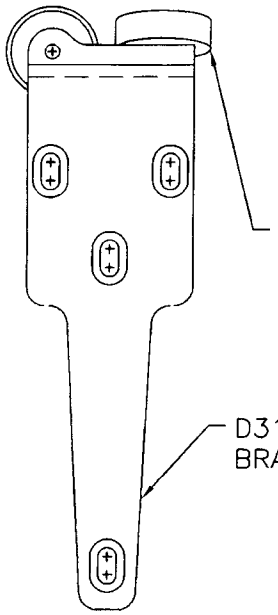


D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07



D3121-143 (SHOWN) / D3121-144 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)

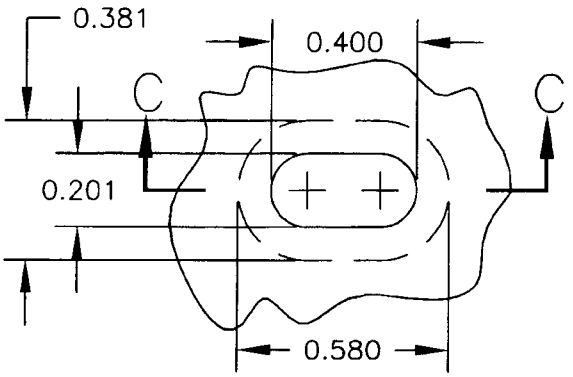


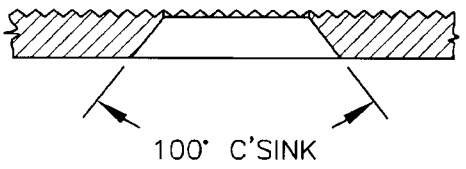
D3121-145 (SHOWN) / D3121-146 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

9214

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED

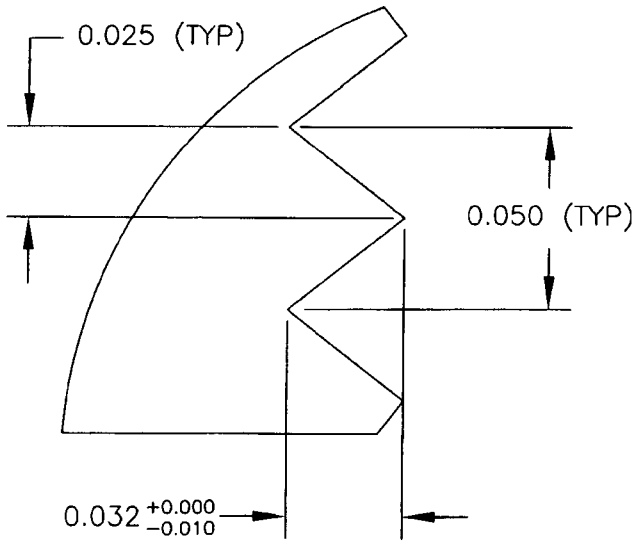




SECTION C–C

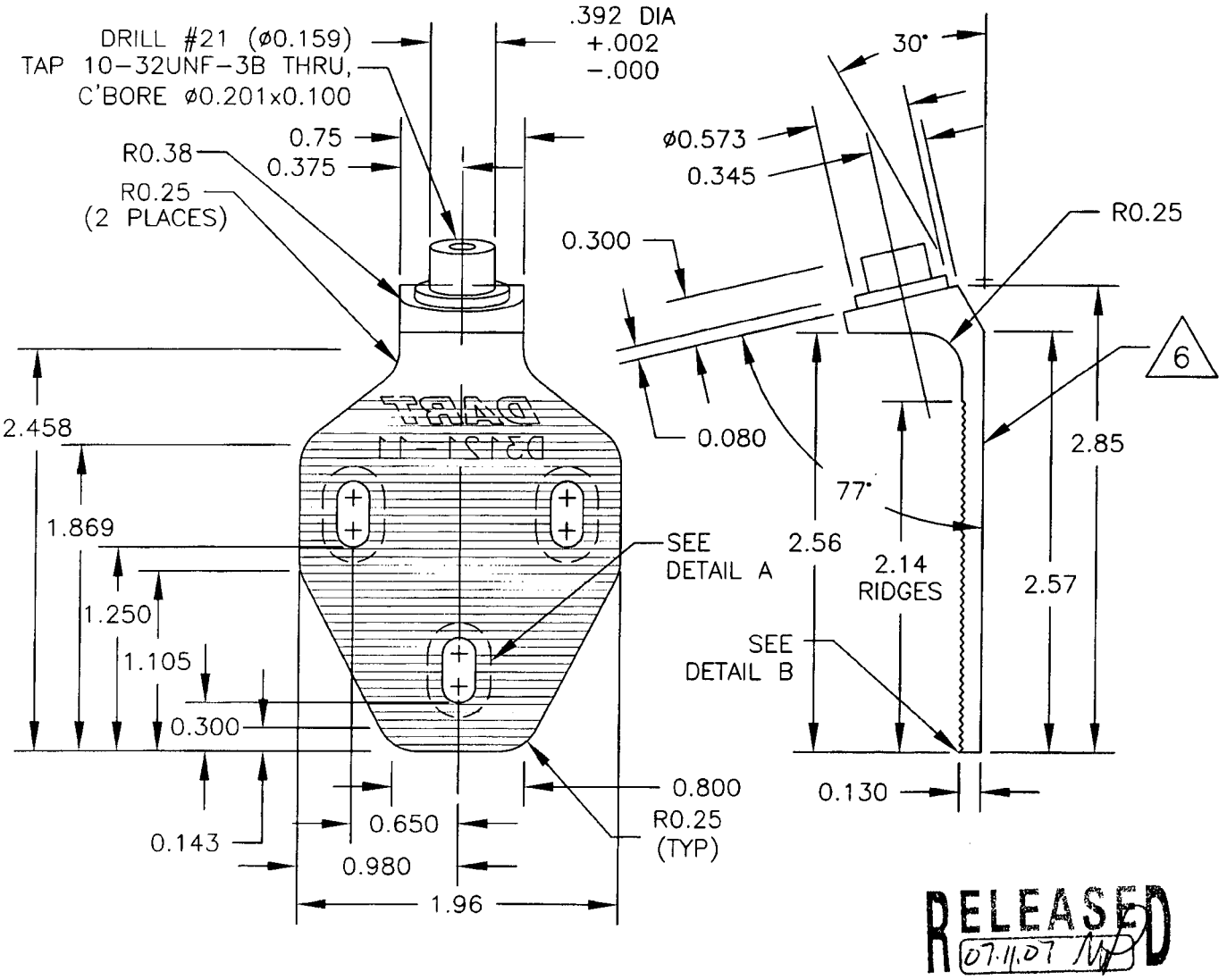
RELEASED
07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



h1266

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 4 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



RELEASED
07.11.07

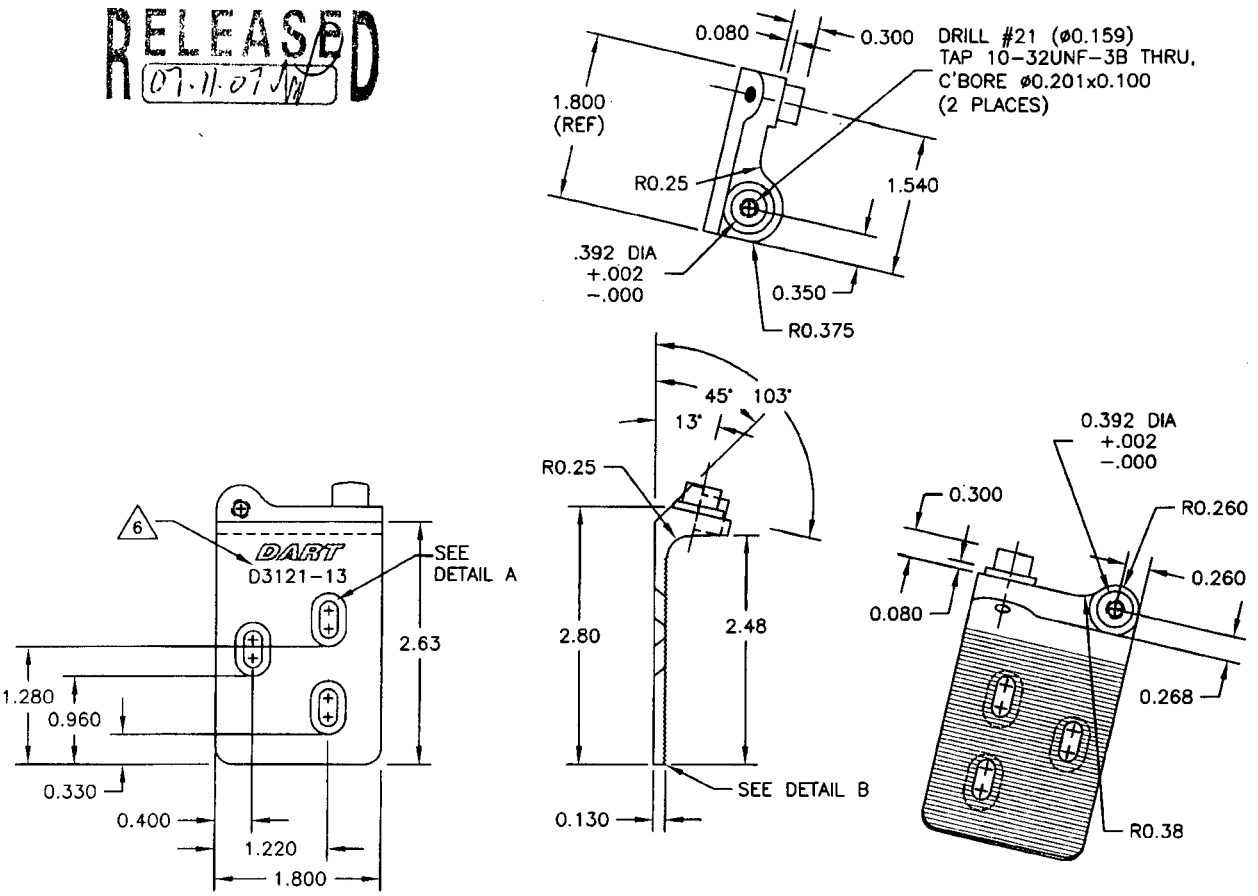
D3121-11 BRACKET

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

9214

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



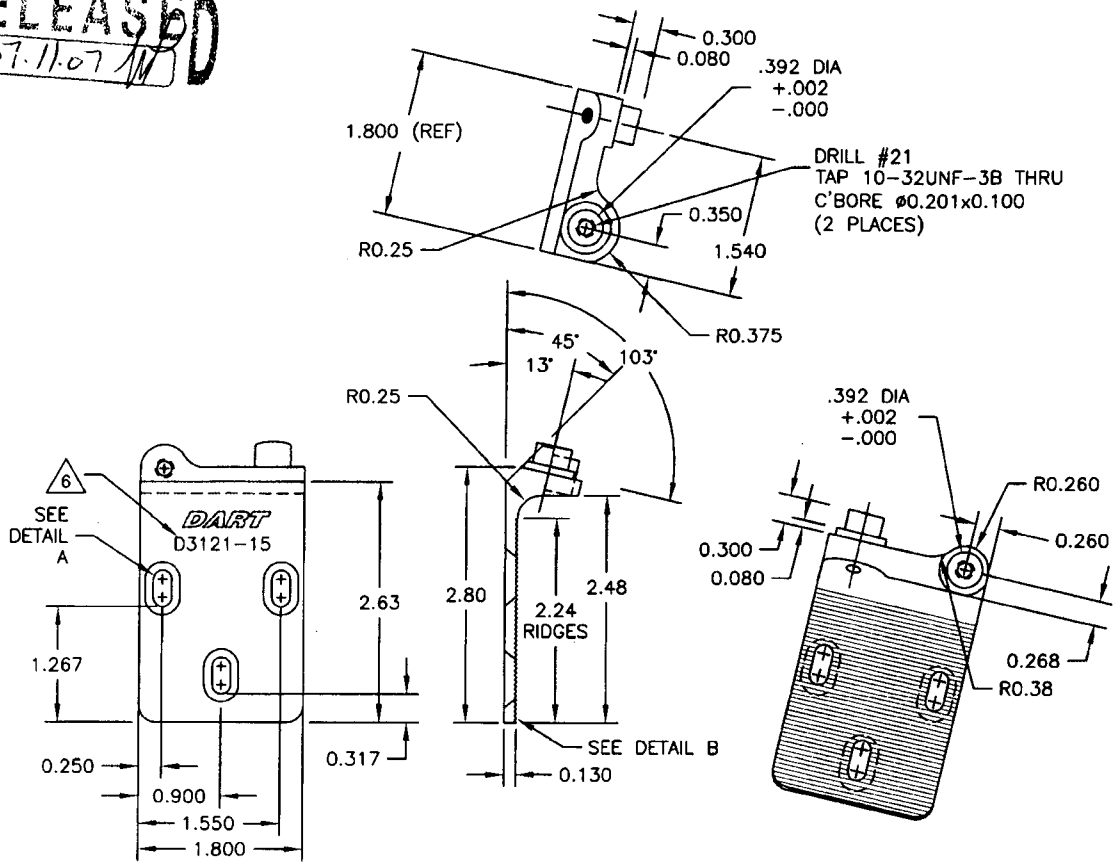
D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

7124b

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 6 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



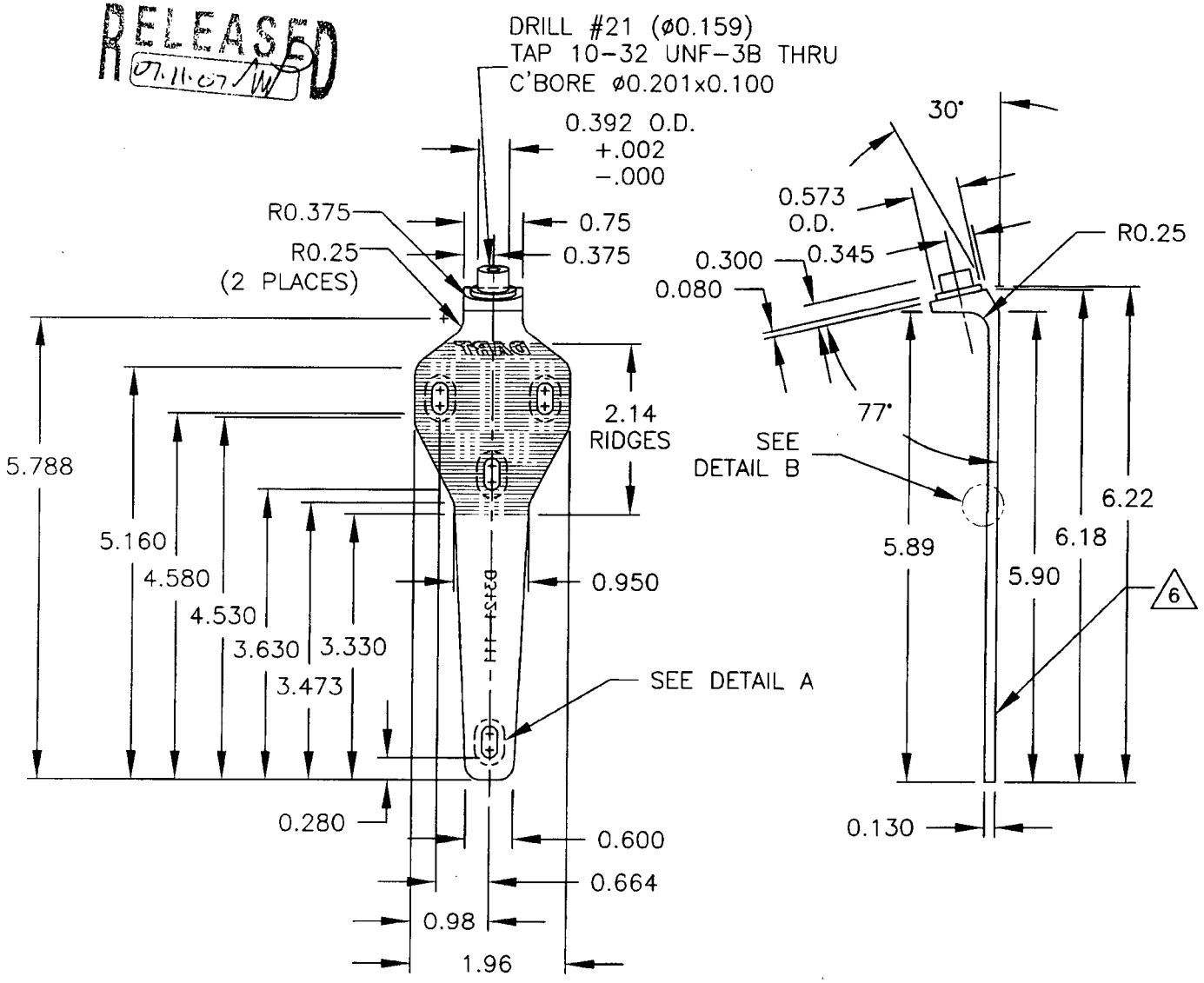
D3121−15 BRACKET (SHOWN)
D3121−16 BRACKET (OPPOSITE)

1) MATERIAL: 17−4 SS PER AMS 5604/5643 (REF DART SPEC. M17−4−B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N AND LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

94214

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07 MW

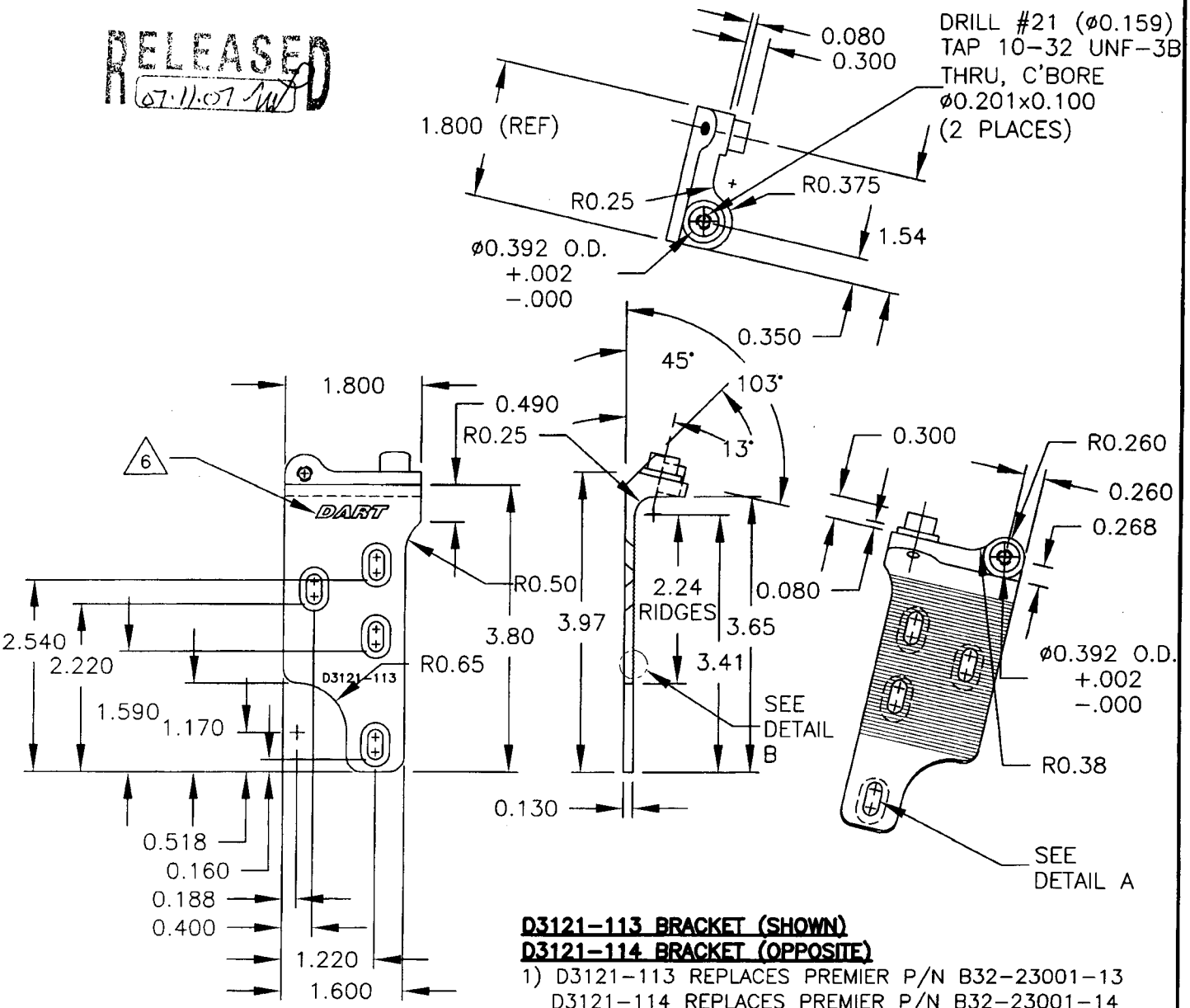


D3121-111 BRACKET

1) REPLACES PREMIER P/N B32-23001-11
2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



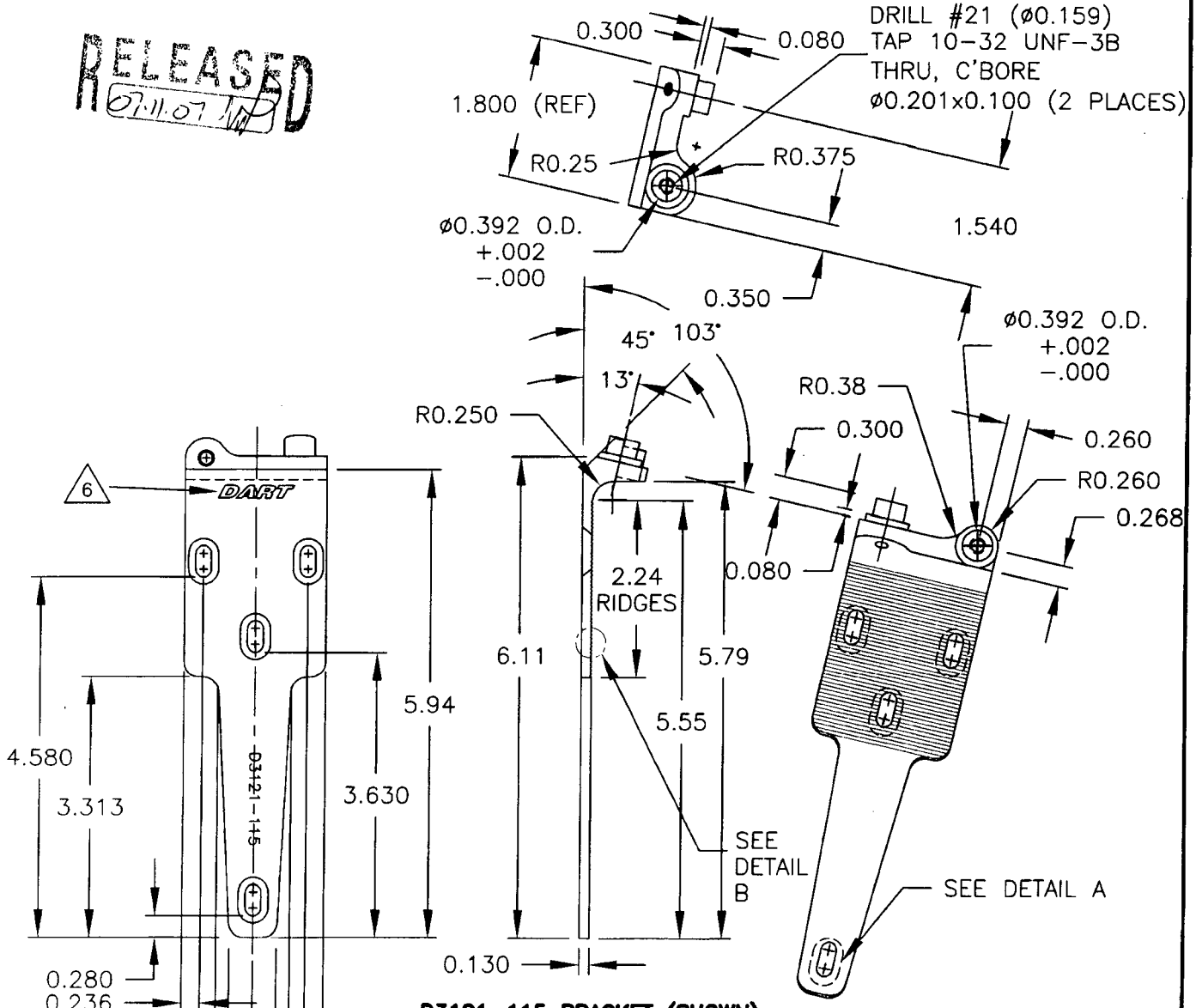
D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

1) D3121-113 REPLACES PREMIER P/N B32-23001-13
   D3121-114 REPLACES PREMIER P/N B32-23001-14
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

D3121

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

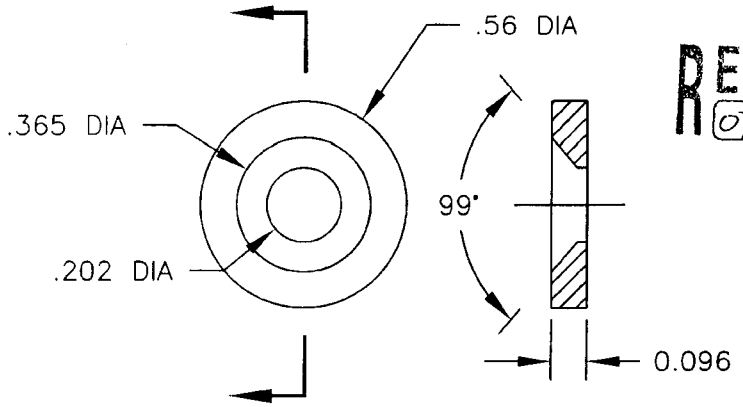


D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

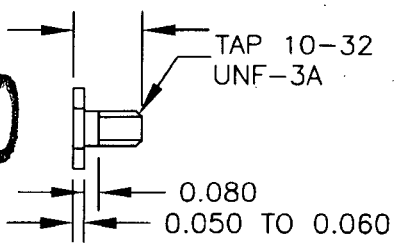
1) D3121-115 REPLACES PREMIER P/N B32-23001-15
   D3121-116 REPLACES PREMIER P/N B32-23001-16
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

9424

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



RELEASED
07.11.07

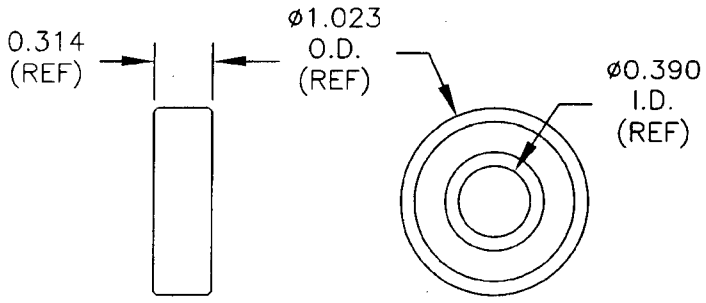


D3121-17 WASHER (SCALE 2:1)

1) REPLACES PREMIER P/N B32-23001-17
2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015

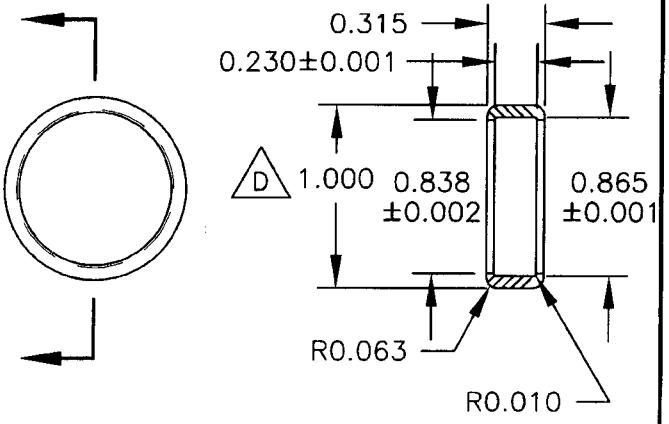
D3121-21 BOLT (SCALE 1:1)

1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



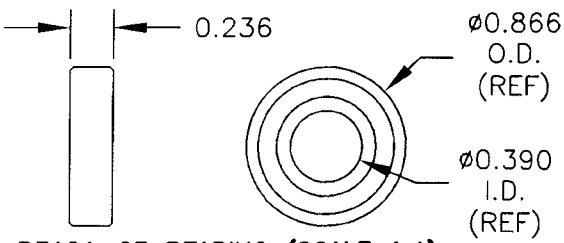
D3121-19 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
2) ALL DIMENSIONS ARE IN INCHES



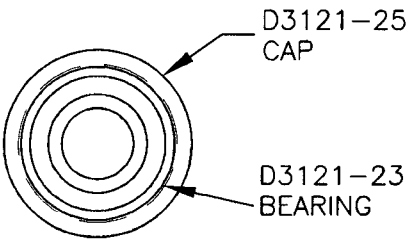
D3121-25 CAP (SCALE 1:1)

1) MATERIAL: DELRIN ROD, ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-ZZ
2) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)